

Date: Monday, 11/21/2005 7:39:24 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FLOAT WEB
Job Number	24864		Part Number	D3289041
Estimate Number	10792		Drawing Number	D3289 REV B
P.O. Number	N/A		Project Number	N/A
This Issue	11/21/2005	S.O. No.	Type	LANDING GEAR
Prsht Rev.	NC		Material	B
First Issue	N/A		Due Date	N/A
Previous Run	N/A		Qty:	10 Um: Each
Written By	<u>SEE COMMENT Below</u>			
Checked & Approved By	<u>SEE ABOVE USER & DATE</u>			
Comment	Est Rev:A 04.09.28 New Issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)		
Pick:		
Qty Part Number	Description Batch	
1 D2600-5-108	Web B24410	DP 06-3-1
2.0	D32833	Doubler
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)		
Pick:		
Qty Part Number	Description Batch	
2 D3283-3	Doubler B24885-B25879	DP 06-3-1
3.0	MS20470AD47	Rivet, Universal Head
Comment: Qty.: 85.0000 Each(s)/Unit Total : 850.0000 Each(s)		
Pick:		
Qty Part Number	Description Batch	
85 MS20470AD4-7	Rivet 415924/119185	DP 06-3-1
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5-108 to 96.7" as per Dwg D3289

2-Transfer drill web from D3283-3 doublers

3-Drill web using DT8748 as per Dwg D3289

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	(O)								

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 7:39:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 24864

Part Number: D3289041

Job Number:



Seq. #: Machine Or Operation:

Description :

4-Using uni-bit, open holes as per Dwg D3289

ST 06-03-10 (10)

5-Deburr holes and ends

ST 06-03-13 (10)

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ST 06-03-22 (10)

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-03-23

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Rivet doublers as per Dwg D3289

A/R LPS-3 Batch: M17395

ST 06-03-30 (10)

8.0 QC5

INSPECT WORK TO CURRENT STEP



06-03-30

P10

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



06-03-30

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Linda Lacelle

ST 06-03-30 (10)

10.0 DC

DOCUMENT CONTROL



(10)

Comment: DOCUMENT CONTROL

Inspection Level 21



06-03-31

Job Completion



06-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-30	7.0	3 holes oversized while removing damaged rivets in the web and doublers, on 1 web only.	J.D. 06/03/13	Scrap, And use our test tube bending		J.D. 06-03-30	J.D. 06/03/13	J.D. 06-03-30

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024864
Project Name : D3289-041
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3289-041
Description : Float Web (206A/B)
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-20-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :

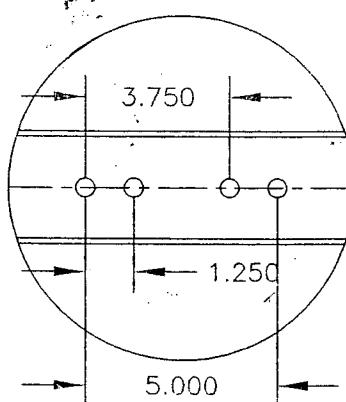
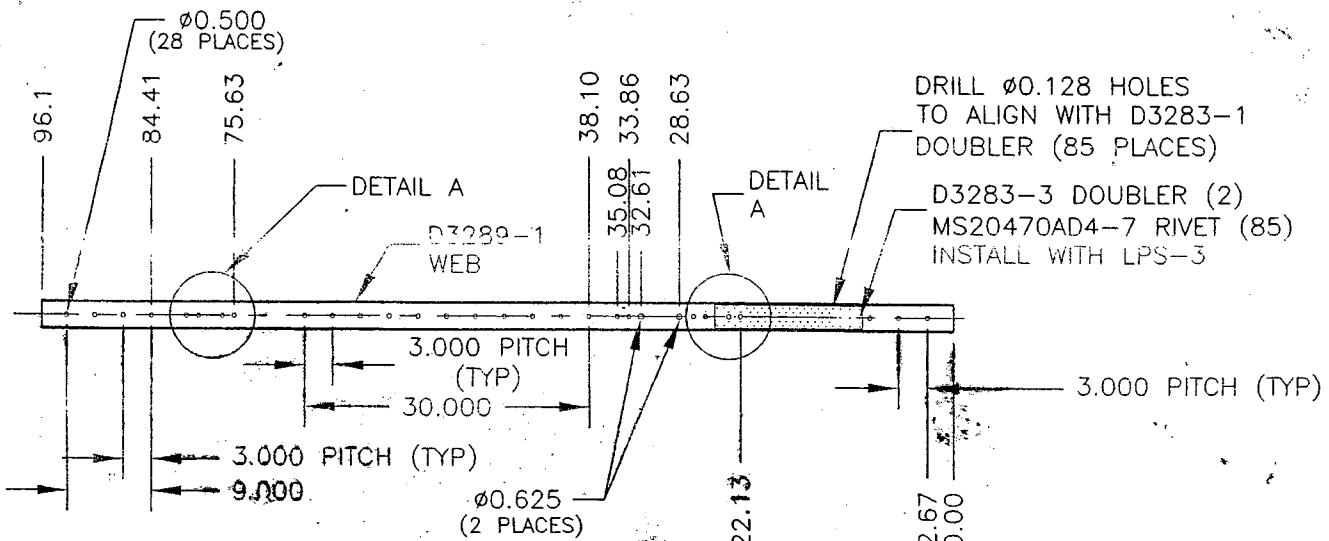
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice Status : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLER CABLE



DETAIL A
SCALE 1:5
RIVET HOLES NOT SHOWN

- 1) MAKE FROM D2600-5-108 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART-QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES AND ARE BETWEEN CENTER LINES
AND D3283-1 WEB. INSTALL RIVETS COATED IN LPS LABORATORIES LPS-3

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADCO WA
DATE				DRAWING NO.
A	04.05.18			D3289
B	05.03.16			FLOAT WEB, 206A/B
				SIG. REV. SC. QC.

